



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18561
Job Sheet 189078



8666

Part No: RBT18561

Job Qty: 1 pcs

Part Name: Bell 407 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18561 Rev3 (TEO17-640) IPP Rev A 17.12.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/8/19	0.00	0.00		Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	3/8/19	0.00	1.00		Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLL
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 4	1 pcs	3/8/19	0.00	0.00	QC 5	QC 4 - 26		
							QC 4 - 28		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/8/19	0.00	0.00		Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		



Dart Aerospace Ltd.
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Container No: S162583



Part: RBT18561

Job No: 189078

Serial No/Batch: S162583

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 03/14/19

Plex 2/11/19 3:13 PM Dart.Hadley.Shannon

Part Op **100** - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case
110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case
120 - QC4- 100% Inspect kits for completeness
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1700-EGA 152F	Case	1 Ea (1 ea)	100-Small Fab - 1	5151858
3896T31 26	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	110-Small Fab - 2 - B4B	5122137
97524A032 40	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5145165
CL-2-C 26	Lanyard Wire	1 ft (1 ea)	110-Small Fab - 2 - B4B	5119833
74 RB H4713	Drain Hose	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5143274
74 RB H4749	Drain Hose	1 pcs (1 ea)	110-Small Fab - 2 - B4B	-5126174
140 RB23006782	Adapter, Torque Turbine Attach Lower Nut	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5142127
141 RB23006783	Adapter, Torque Turbine Attach Upper Nut	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5136414
151 RB23007615	Power Turbine Support Cleaning C-30 & C-47	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5153384
1390 RB23007638	Fuel Injector Wrench	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5145390
1408 RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 2 - B4B	502040
144 RBBP1425-101	Input Drive Shaft Tool (K-Flex)	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5157326
141C RBE2-10-1	Fuel System Cartridge Removal Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5157201
145 RBT112800	Power Take Off Seal Installation Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5153520
144A RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5141259
59 RBT18034	Main Rotor Pitch Link Protectors	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5143866
145 RBT18538	Pilot, Co-Pilot Seat Brace	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5129061
145B RBT18560	Engine Gearbox Seal Puller	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5057990
RBT18561-11	Needle Nozzle Grease Gun	2 Ea (2 ea)	110-Small Fab - 2 - B4B	5077640
RBT18561-13	Relay Base Removal	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5043350
RBT18561-15	Extract Tool - Blue	2 Ea (2 ea)	110-Small Fab - 2 - B4B	-5148645
RBT18561-17	Extract Tool - Red	2 Ea (2 ea)	110-Small Fab - 2 - B4B	-5148646
RBT18561-19	Extract Tool - Green	2 Ea (2 ea)	110-Small Fab - 2 - B4B	5148647
RBT18561-21	Extract Tool - Terminal Block	1 Ea (1 ea)	110-Small Fab - 2 - B4B	-5151534
RBT18561-23	Extract Tool - Terminal Block	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5141267
RBT18561-25	Relay Removal	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5151193
RBT18561-27	Posi-Drive Bits-Main Rotor Beanie	2 Ea (2 ea)	110-Small Fab - 2 - B4B	-5045223
RBT18561-29	Extraction Tool	1 Ea (1 ea)	110-Small Fab - 2 - B4B	-5079676
RBT18561-31	10X Magnifier Glass	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5133296
RBT18561-35	Offset 5/16 Torque Adapter	1 Ea (1 ea)	110-Small Fab - 2 - B4B	-5152503
RBT18561-37	Offset 3/8 Torque Adapter	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5155899
RBT18561-39	Offset 1/2 Torque Adapter	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5136891
RBT18561-41	Offset 9/16 Torque Adapter	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5044610
RBT18561-45	A/C Belt Tensioner	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5136893
RBT18561-49	Tygon Hose	1 ft (1 ea)	110-Small Fab - 2 - B4B	5048059
RBT18561-7	Crowfoot	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5136873
RBT18561-75	Bottom Foam use in case APP-1700-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	-5151852
RBT18561-77	Top Foam use in case APP-1700-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5151857
RBT18561-79	Stiffener (0.236 x 13-3/4 x 35-1/2, Coroplast, Black)	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5151855
85 RBT18561-81	Contents & Location Placard	1 Ea (1 ea)	110-Small Fab - 2 - B4B	-5048414
77 RBT18561-89	Storage Box	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5141273
8.5 RBT18561-9	Insert Tool-Whelen Connectors	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5141260
146 RBT18582	Tail Rotor Gear Box Torque Adapter	1 pcs (1 ea)	110-Small Fab - 2 - B4B	-5042581
135A RBT400213	407 Trim Tab Bender	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5127761
136 RBT400214	Trim Tab Bending Gauge	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5145833
136A RBT400325	Tail Boom Nut Socket (407)	1 pcs (1 ea)	110-Small Fab - 2 - B4B	-5152572
102 RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5142839
	Hammer, Aluminum	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5135407

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1700-E	1	31	0
110-Small Fab - 2 - B4B	3896T31	2	796	0
	97524A032	4	514	0
	CL-2-C	1	484	0
	RB H4713	1	6	0
	RB H4749	1	3	0
	RB23006782	1	7	0
	RB23006783	1	12	0
	RB23007615	1	0	0
	RB23007638	1	8	0
	RB41011	1	417	0
	RBBP1425-101	1	3	0
	RBE2-10-1	1	1	0
	RBT112800	1	1	0
	RBT18025-13	1	22	0
	RBT18034	1	5	0
	RBT18538	1	3	0
	RBT18560	1	5	0
	RBT18561-11	2	22	0
	RBT18561-13	1	14	0
	RBT18561-15	2	26	0
	RBT18561-17	2	26	0
	RBT18561-19	2	26	0
	RBT18561-21	1	21	0
	RBT18561-23	1	21	0
	RBT18561-25	1	14	0
	RBT18561-27	2	25	0
	RBT18561-29	1	17	0
	RBT18561-31	1	10	0
	RBT18561-35	1	13	0
	RBT18561-37	1	9	0
	RBT18561-39	1	9	0
	RBT18561-41	1	9	0
	RBT18561-45	1	14	0
	RBT18561-49	1	66	0
	RBT18561-7	1	9	0
	RBT18561-75	1	18	0
	RBT18561-77	1	18	0
	RBT18561-79	1	17	0
	RBT18561-81	1	4	0
	RBT18561-89	1	13	0
	RBT18561-9	1	10	0
	RBT18582	1	13	0
	RBT400213	1	4	0
	RBT400214	1	5	0
	RBT400325	1	15	0
	RBW109-3101-58-1-1	1	9	0
	RBW109-3101-58-2-1	1	3	0

Part Specifications

Specifications could not be found.

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Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18561 Rev3 (TEO17-640) IPP Rev A 17.12.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/8/19	3/8/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs	3/8/19	3/8/19	0.00	1.00	Small Fab-9		
120	QC	1 pcs	3/8/19	3/8/19	0.00	0.00	QC4		
130	Packaging	1 pcs	3/8/19	3/8/19	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea	3/8/19	3/8/19	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	
APP-1700-E	Case	1 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	1 ft (1 ea)	90-Start up Operation	
RB H4713	Drain Hose	1 Ea (1 ea)	90-Start up Operation	
RB H4749	Drain Hose	1 pcs (1 ea)	90-Start up Operation	
RB23006782	Adapter, Torque Turbine Attach Lower Nut	1 pcs (1 ea)	90-Start up Operation	
RB23006783	Adapter, Torque Turbine Attach Upper Nut	1 Ea (1 ea)	90-Start up Operation	
RB23007615	Power Turbine Support Cleaning C-30 & C-47	1 Ea (1 ea)	90-Start up Operation	
RB23007638	Fuel Injector Wrench	1 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	
RBBP1425-101	Input Drive Shaft Tool (K-Flex)	1 Ea (1 ea)	90-Start up Operation	

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RBE2-10-1	Fuel System Cartridge Removal Tool	1 Ea (1 ea)	90-Start up Operation
RBT112800	Power Take Off Seal Installation Tool	1 Ea (1 ea)	90-Start up Operation
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	90-Start up Operation
RBT18034	Main Rotor Pitch Link Protectors	1 Ea (1 ea)	90-Start up Operation
RBT18538	Pilot, Co-Pilot Seat Brace	1 Ea (1 ea)	90-Start up Operation
RBT18560	Engine Gearbox Seal Puller	1 Ea (1 ea)	90-Start up Operation
RBT18561-11	Needle Nozzle Grease Gun	2 Ea (2 ea)	90-Start up Operation
RBT18561-13	Relay Base Removal	1 Ea (1 ea)	90-Start up Operation
RBT18561-15	Extract Tool - Blue	2 Ea (2 ea)	90-Start up Operation
RBT18561-17	Extract Tool - Red	2 Ea (2 ea)	90-Start up Operation
RBT18561-19	Extract Tool - Green	2 Ea (2 ea)	90-Start up Operation
RBT18561-21	Extract Tool - Terminal Block	1 Ea (1 ea)	90-Start up Operation
RBT18561-23	Extract Tool - Terminal Block	1 Ea (1 ea)	90-Start up Operation
RBT18561-25	Relay Removal	1 Ea (1 ea)	90-Start up Operation
RBT18561-27	Posi-Drive Bits-Main Rotor Beanie	2 Ea (2 ea)	90-Start up Operation
RBT18561-29	Extraction Tool	1 Ea (1 ea)	90-Start up Operation
RBT18561-31	10X Magnifier Glass	1 Ea (1 ea)	90-Start up Operation
RBT18561-35	Offset 5/16 Torque Adapter	1 Ea (1 ea)	90-Start up Operation
RBT18561-37	Offset 3/8 Torque Adapter	1 Ea (1 ea)	90-Start up Operation
RBT18561-39	Offset 1/2 Torque Adapter	1 Ea (1 ea)	90-Start up Operation
RBT18561-41	Offset 9/16 Torque Adapter	1 Ea (1 ea)	90-Start up Operation
RBT18561-45	A/C Belt Tensioner	1 Ea (1 ea)	90-Start up Operation
RBT18561-49	Tygon Hose	1 ft (1 ea)	90-Start up Operation
RBT18561-7	Crowfoot	1 Ea (1 ea)	90-Start up Operation
RBT18561-75	Bottom Foam (3 x 13-3/4 x 36, Ethafoam 220, Black)	1 Ea (1 ea)	90-Start up Operation
RBT18561-77	Top Shelf Foam (2-1/16 x 13-3/4 x 35-1/2, Ethafoam 220, Black)	1 Ea (1 ea)	90-Start up Operation
RBT18561-79	Stiffener (0.236 x 13-3/4 x 35-1/2, Coroplast, Black)	1 Ea (1 ea)	90-Start up Operation
RBT18561-81	Contents & Location Placard	1 Ea (1 ea)	90-Start up Operation
RBT18561-89	Storage Box	1 Ea (1 ea)	90-Start up Operation
RBT18561-9	Insert Tool-Whelen Connectors	1 Ea (1 ea)	90-Start up Operation
RBT18582	Tail Rotor Gear Box Torque Adapter	1 pcs (1 ea)	90-Start up Operation
RBT400213	407 Trim Tab Bender	1 Ea (1 ea)	90-Start up Operation
RBT400214	Trim Tab Bending Gauge	1 Ea (1 ea)	90-Start up Operation
RBT400325	Tail Boom Nut Socket (407)	1 pcs (1 ea)	90-Start up Operation
RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	90-Start up Operation

RBW109-3101-58-2-1 Hammer, Aluminum

1 Ea (1 ea) 90-Start up
Operation**Job Allocations**

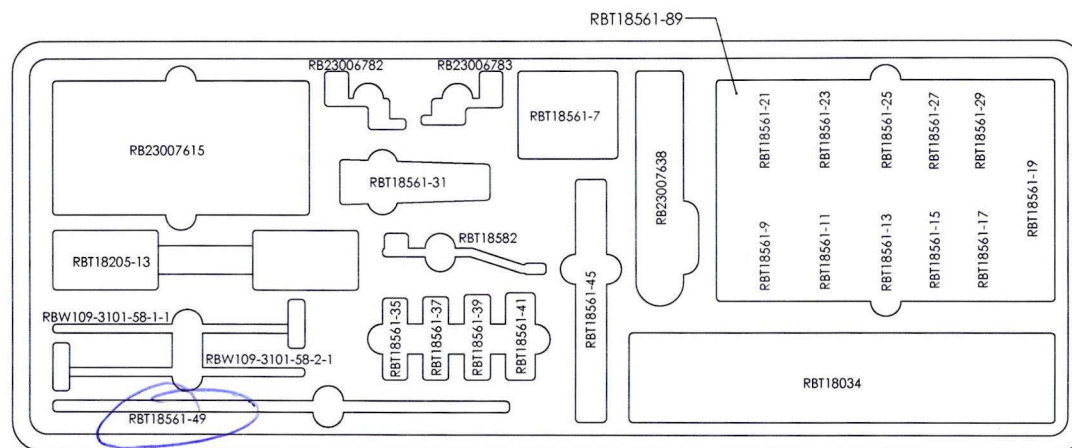
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	618	0
	97524A032	4	771	0
	APP-1700-E	1	19	0
	CL-2-C	1	493	0
	RB H4713	1	9	0
	RB H4749	1	4	0
	RB23006782	1	7	0
	RB23006783	1	12	0
	RB23007615	1	0	0
	RB23007638	1	9	0
	RB41011	1	490	0
	RBBP1425-101	1	0	0
	RBE2-10-1	1	1	0
	RBT112800	1	2	0
	RBT18025-13	1	22	0
	RBT18034	1	6	0
	RBT18538	1	3	0
	RBT18560	1	2	0
	RBT18561-11	2	12	0
	RBT18561-13	1	9	0
	RBT18561-15	2	16	0
	RBT18561-17	2	16	0
	RBT18561-19	2	16	0
	RBT18561-21	1	9	0
	RBT18561-23	1	9	0
	RBT18561-25	1	9	0
	RBT18561-27	2	13	0
	RBT18561-29	1	7	0
	RBT18561-31	1	10	0
	RBT18561-35	1	7	0
	RBT18561-37	1	9	0
	RBT18561-39	1	9	0
	RBT18561-41	1	9	0
	RBT18561-45	1	8	0
	RBT18561-49	1	66	0
	RBT18561-7	1	9	0
	RBT18561-75	1	6	0
	RBT18561-77	1	6	0
	RBT18561-79	1	5	0
	RBT18561-81	1	4	0
	RBT18561-89	1	13	0
	RBT18561-9	1	10	0
	RBT18582	1	13	0
	RBT400213	1	4	0
	RBT400214	1	6	0
	RBT400325	1	3	0
	RBW109-3101-58-1-1	1	9	0
	RBW109-3101-58-2-1	1	3	0

Part Specifications

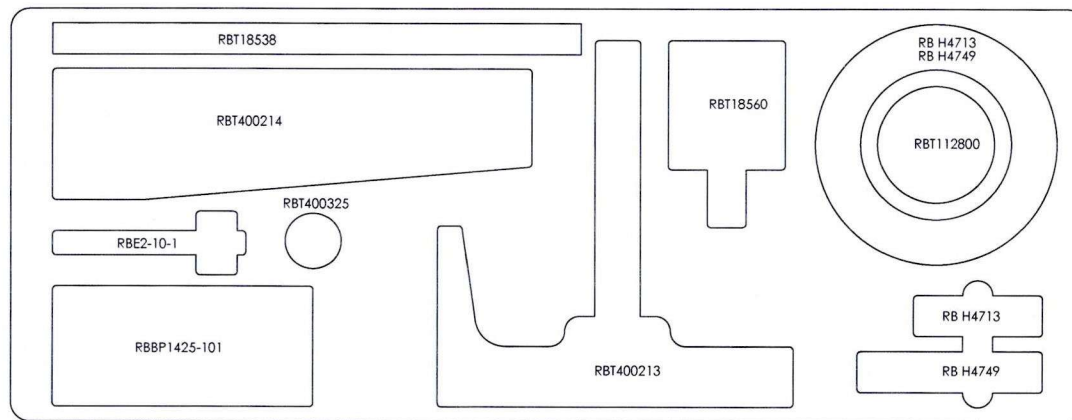
Specifications could not be found.

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TOP SHELF



BOTTOM CUSHION

TOOL LAYOUT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED -11 B/O P/N FROM 6Y900 TO GY900.	1/14/2013	RJC	SE
1		CHD -75 TOOL LAYOUT, ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUPS FOR INDIVIDUAL QUILS (RB H4713, RB H4749), MOVED RBT112800, CHD SQUEEZE BOTTLE DEPIHS FROM 2.45 TO 2.35 & 3.43 TO 3.08.	1/14/2013	RJC	SE
1A		-7 CHD BOM INFO WAS 1/2 DRIVE IS 3/8 DRIVE, -13 NUMBER WAS M6106/32-002 IS M6106/32-001.	3/8/2013	BIM	SE
1B		CORRECTED T/N ON BOTTOM TOOL LAYOUT WAS RBT400325 IS RBT400325.	1/21/2014	RJC	RJC
2	16-0139	-75 & -77 CHD MATERIAL & SUPPLIER WAS Y20 BLACK, I.R. SPECIALTY IS ETHAFOAM 220, BLACK, CASE SOLUTIONS, -75 DELETED RBT18561-39 & RBT18561-61 FROM KIT AND CHD TOOL LAYOUT, CHD DIM WAS 4X R 64 IS 3X .65 X 45°, -77 ADDED CUTOUPS FOR RBW109-3101-58-1, RBW109-3101-58-2 AND RBT18034, DELETED -33 AND ADDED -34 AND CHD CUTOUP FOR NEW SCALE, -79 CHD DIM WAS 28.44 IS 35.50, ADDED BLACK TO COROPLAST MATERIAL CALLOUT, -81 UPDATED WITH NEW S AND DELETED TOOLS, CHD PAPER WAS WHITE IS RED.	9/2/2016	RJC	JAG
3	16-0251	CORRECTED DWG. TITLE WAS FIELD TOOL KIT IS 407 FIELD MAINTENANCE KIT, CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1, -31 ADDED B/O INFO (MCMASER-CARR #6485113), -75, -77, -79, -81 CHD DWG. TO SHEET METAL TOLERANCE, -75, -77 ADDED DIM 4X R 64, -81 CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1.	12/5/2016	RJC	SM

**TEO ATTACHED
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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 189078 MJS
1901-18

DART AEROSPACE																																			
TITLE 407 FIELD MAINTENANCE KIT																																			
DWG NO. RBT18561	REV 3																																		
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date :		Sequence #:		QTY Affected :		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
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